



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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S257311

D3319-3

Job Sheet 204609-A



Part No: D3319-3

Part Name: Full Length Wearplate



Part Weight: 0 lbs

Job Created: 2/21/20

Due Date: 2/21/20

Type: Stock

Ship Via:

Job Qty: 5 pcs

DAS
21
9-88

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
150	QC 5	5 pcs	2/21/20		0.00	0.00	QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			
160	Automated Welding - B4B	5 pcs	2/21/20		0.00	1.59	Automated Welding - 1 - B4B			MV
170	QC 10	5	2/21/20		0.00	0.00	QC 10 - 10			
							QC 10 - 18			
							QC 10 - 24			
							QC 10 - 43			
							QC 10 - 50			
							QC 10 - 58			
							QC 10 - 9			
							QC 10 - 68			
							QC 5 - 10			
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			



Container No: S257311



Part: D3319-3

Job No: 204609-A

Serial No/Batch: S254288

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
TEL: 1 613 632-5200
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Date: 02/26/20

					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	Q
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	DAS
190	Spray Paint - 2 - B4B	5 pcs	2/21/20	0.00 0.50	Spray Paint - 1 - B4B	41 FEB 27 2020
					Spray Paint - 2 - B4B	9-89
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200	QC 3	5 pcs	2/21/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	MAR 03 2020
					QC 3 - 19	DAS
					QC 3 - 43	82
					QC 3 - 24	9-89
					QC 3 - 61	
					QC 3 - 81	
210	Packaging 3-1 - Stock - B4B	5 pcs 4x pcs M/D	2/21/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	DAS
					Packaging 3 - 5 - B4B	28
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	5	2/21/20	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

DAS

21

MAR 03 2020

3-88

Part Op **150** - (QC5- Inspect part completeness to step on W/O)
 Descriptions: **160** - 8259 Hardcoat Rod _____
170 - (QC10- Inspect visual per QSI004- ground welds)
180 - (QC5- Inspect part completeness to step on W/O)
190 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
 BATCH: 5257420
200 - (QC3- Inspect Part Finish)
210 - (Identify as per dwg & Stock Location: _____) Identify on inside surface using a permanent fine point marker with the following:
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189		
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499		
3	Wearplate	0.316inches ± 0.010	0.326 0.306		
4	Wearplate	0.607inches ± 0.010	0.617 0.597		
5	Wearplate	2.940inches ± 0.030	2.970 2.910		
6	Wearplate	2.690inches ± 0.030	2.720 2.660		
7	Wearplate	3.527inches ± 0.010	3.537 3.517		
8	Wearplate	4.520inches ± 0.030	4.550 4.490		
9	Wearplate	5.063inches ± 0.010	5.073 5.053		
10	Wearplate	6.160inches ± 0.030	6.190 6.130		
11	Wearplate	0.600inches ± 0.030	0.630 0.570		

12	Wearplate	8.690inches $\pm$ 0.010	8.700 8.680
13	Wearplate	30.790inches $\pm$ 0.010	30.800 30.780
14	Wearplate	52.880inches $\pm$ 0.030	52.910 52.850
15	Wearplate	62.770inches $\pm$ 0.010	62.780 62.760
16	Wearplate	74.420inches $\pm$ 0.010	74.430 74.410
17	Wearplate	75.520inches $\pm$ 0.030	75.550 75.490
18	Wearplate	0.050inches $\pm$ 0.010	0.060 0.040

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D3319-3
Job Sheet 204609



Part No: D3319-3

Part Name: Full Length Wearplate

Job Qty: ~~12~~ ¹⁰ pcs



Part Weight: 0 lbs

Job Created: 12/13/19

Due Date: ~~1/17/20~~ ^{Jun 28}

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B Now on Waterjet 06-10-03 JLM IPP REV:C 17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		1/17/20	0.17	2.80	Waterjet - Flow		<i>20/02/10</i>
110	QC 2	12 pcs		1/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		<i>20/02/10</i>
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	12 pcs	1/17/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Small Fab - Brake NC - B4B	12 pcs	1/17/20	0.25 0.80	Small Fab - Brake - 1 - B4B	DAS 30 FEB 12 2020
				Small Fab - Brake - 2 - B4B	9-89
				Small Fab - Brake - 3 - B4B	
150 QC 5	12 pcs	1/17/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
160 Automated Welding - B4B	12 pcs	1/17/20	0.00 3.82	Automated Welding - 1 - B4B	MLV Feb 10/20
170 QC 10	12	1/17/20	0.00 0.00	QC 10 - 10	

	pcs			QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
180 QC 5	12 pcs	1/17/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Spray Paint - 2 - B4B	12 pcs	1/17/20	0.00 1.20	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
200 QC 3	12 pcs	1/17/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
210 Packaging 3-1 - Stock - B4B	12 pcs	1/17/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	1/17/20	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg D3319 Dwg Rev: D Prog Rev: D 2-Deburr if necessary
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 140 - Form using DT8326 & DT8261 as per Dwg D3319
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - 8259 Hardcoat Rod M/39/27
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - COAT ENTIERED TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE.
 BATCH: _____
 200 - (QC3- Inspect Part Finish)
 210 - (Identify as per dwg & Stock Location: _____) Identify on inside surface using a permanent fine point marker with the following:
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	39 sf (3.25 ea)	100-Waterjet - Flow - 1	5242863

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	39	166	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0.192	
2	Wearplate	0.500inches + 0.006 - 0.001	0.506 0.499	0.499	
3	Wearplate	0.316inches ± 0.010	0.326 0.306	0.314	
4	Wearplate	0.607inches ± 0.010	0.617 0.597	0.607	
5	Wearplate	2.940inches ± 0.030	2.970 2.910	2.950	
6	Wearplate	2.690inches ± 0.030	2.720 2.660	2.704	
7	Wearplate	3.527inches ± 0.010	3.537 3.517	3.527	
8	Wearplate	4.520inches ± 0.030	4.550 4.490	4.52	
9	Wearplate	5.063inches ± 0.010	5.073 5.053	5.059	
10	Wearplate	6.160inches ± 0.030	6.190 6.130	6.158	
11	Wearplate	0.600inches ± 0.030	0.630 0.570	0.610	
12	Wearplate	8.690inches ± 0.010	8.700 8.680	8.694	
13	Wearplate	30.790inches ± 0.010	30.800 30.780	30.790	
14	Wearplate	52.880inches ± 0.030	52.910 52.850	52.880	
15	Wearplate	62.770inches ± 0.010	62.780 62.760	62.770	
16	Wearplate	74.420inches ± 0.010	74.430 74.410	74.420	
17	Wearplate	75.520inches ± 0.030	75.550 75.490	75.520	
18	Wearplate	0.050inches ± 0.010	0.060 0.040	0.049	

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NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ ☐						Date : _____ Sequence #: _____		QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation				Disposition											
Completed By				Lead hand / Supervisor											
								QC / QA Coordinator							
Root Cause Operator ☐ ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐ ☐				FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐ ☐ Pressure/Forced ☐ ☐ ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐ ☐ Other/Details: _____				Power Loss/Surge ☐ ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐ ☐				Positioned Wrong ☐ ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐ ☐			